Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-11 **Date Opened:** 4 Jan 16 **Title:** Assembly

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket **Product Model:** Long **Quantity:** 1

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	N/A
Completed Certification	JR
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JR
Dual Inspections Initialled	JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
78410	2	Basket Assembly	JR
78427	2	Placard	JR
70405	4	Lid Walkway	JR
84261	2	Handle Assembly	JR

Traveller

	Initial or N/A
Install walkway on lid	JR
Install lid on basket body	JR
Re-tap mounting lug holes and install mount lugs	JR
Install handle brackets	JR
Install handle	JR
Install lid prop	JR
Install data plate	JR

Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	JR
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

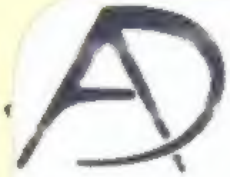
Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JR
Research and Development	N/A
Third Party	N/A

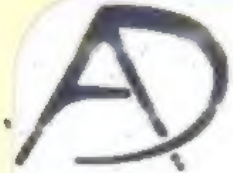
Work performed by:	Print: Andrew Bartfai	Sign:	SCA: AD07	Date: 13-Jan-16
ICC / Dual Inspection preformed by:	Print: Jeff Clarke	Sign:	SCA: AD02	Date: 13-Jan-16
Work Order closed by:	Print: Jason Rekve	Sign:	SCA: AD01	Date: 13-Jan-16



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	78412-01	
Aircraft:	Eurocopter	Model: AS350/355
Description:	Long Basket Lid	
Supplier:	Aero Design	
Color:	White	
WO#:	2015-132	PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 78411-01
Aircraft: Eurocopter Model: AS350/355
Description: Long Basket Body
Supplier: Aero Design
Color: White
WO#: 2015-132 PO# N/A

Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Aluminum Checker plate

Aircraft: All Model: All

Description: 5 7/8" x 10', .065", pattern c102

Supplier: Daigle Marine

Color: N/A

WO#: N/A PO# 15056

Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 25
PN: MS20001P4-9600
Aircraft: All Model: All
Description: Hinge
Supplier: GKN Bandy
Color: N/A
WO#: N/A PO# 15069

78401-60

Aero Design

Parts Distribution Sheet

Description: AS350 LONG BASKET ASSEMBLY WO# 2016-11

From PO or WO #	Quantity	Description	Part Number	For WO #
15056	1	Checker plate		
15031	26	Rivet	CR3213-4-02	
		Silicone		
15069	1	Hinge	MS20001P4	
15031	12	Rivet	CR3523-5-03	
15031	24	Rivet	CR3213-5-02	
WO 2015-122	2	Lever Assembly	84261-02	
14103	1	1"x0.65 SS Tube		
15074	16	Washer	NAS1149F0663P	
15075	8	Stud fitting	96710-01	
WO 2015-69	1	Forward Beam	78634-01-00	
WO 2014-54	2	LH Ext Step	82711-01-02	
13048	2	Nut	MS21044C3	
WO 2015-109	2	Stops	69830-21	
WO 2015-109	2	Knobs	69830-22	
WO 2015-94	4	AS350 Clamp	78620-01	
WO 2015-69	1	LH Aft Beam	78633-01-02	
15066	1	Grip Tape		
14084	1	Bolt	~~AN4-08~~ → AN3-15A	
15031	2	Nut	MS21044N3	
15014	4	Washer	AN970-3	
15031	2	Washer	~~NAS1149F0363R~~ -08	
15031	1	Bolt	AN3-17A	

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

Aero Design

Parts Distribution Sheet

Description: Clamp Assembly WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2015-94	4	Clamp (Threaded Hole)	78620-02	
2015-94	4	Strap	78620-03	
15067	4	Bolt	AN4-14A	
15074	8	Washer	NAS1149FO463P	
14072	4	Nut	MS21044N4	
12125	4	T Bolt	FT4F-175H	
12126	4	Self Aligning Nut	3D0006-4	

Aero Design
Parts Distribution Sheet

WO# _____

From PO or WO #	Quantity	Description	Part Number	For WO #
15067	4	BOLT	AN4-14A	
15074	4	BOLT	AN4-15A	
15074	4	~~AN~~ WASHER	NAS1149F0463P	
15002	12	WASHER 1/4" FENDER	COMMERCIAL	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO2016-11

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Long Cargo Basket	78410-01	1	78401-60	New

12. Remarks

Modified with walkway on lid IAW DCL704

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
Jeff Clark. AD02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	13 Jan 2016		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

FIRE HAWK

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2016 - 11

Date Open: 13 Jan 16

1. Lid Assembly — AD-07
    a. Install lid bumpers on bottom.
        i. Fill bumper holes with RTV silicone sealant.
        ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

    b. Install placard on bracket on top of lid.
        i. Locate placard on bracket.
        ii. Drill #30 through placard and bracket, using holes in placard.
        iii. Remove placard and de-burr holes in placard and on bracket.
        iv. Locate placard on bracket, and cleco in place.
        v. Rivet placard with four CR3213-4-02 CherryMax rivets.

    c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
        i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
        ii. Pull tread plate from stock. Shear tread plate to length.
        iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
        iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
        v. Mark and drill #30 holes:
            1. 0.25" from edge of tread plate, centre on cross members (0.38")
            2. 0.25" from edge of tread plate, middle of each walkway stringer
        vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using ¼" piloted counter bore on both sides.
        vii. De-burr holes in lid tubes.
        viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
        ix. Set tread plate in place, secure with clecos if necessary.
        x. Rivet placard with CR3213-4-02 CherryMax rivets

    d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly — AD-07
    a. Install attachment fittings
        i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
        ii. Run 3/8-24 tap into attachment lugs to clear threads.
        iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
        iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
            1. 90610 (Robinson R44) basket only:
                a. Install 1 fitting 906?? in lower forward attachment lug only.
                b. Install 3 96710-01 fittings in remaining locations.
        v. Torque to ??

b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
   i. Locate 94621-01 Brace over aft cross tube cutout
   ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
   iii. Torque AN4 bolts to ??

c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation AD-07
   a. Prepare hinge.
      i. Cut hinge to length:
         1. 776, 906 – 54"
         2. 751, 803 – 70"
         3. 698, 764, 945 – 72"
         4. 784 – 90"
         5. 940, 946, 959 – 95"
      ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.

   b. Install hinge on basket
      i. Locate hinge on basket (standard baskets)
         1. centre fore/aft
         2. 0.15" – 0.18" up from bottom edge
      ii. Locate hinge on basket (extra wide baskets)
         1. centre fore/aft
         2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
      iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
      iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
      v. Remove hinge and de-burr holes in hinge and basket rim.
      vi. Cleco hinge to basket with 5/32 clecos.
      vii. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

   c. Install lid on basket
      i. Locate lid on hinge (all baskets)
         1. center fore/aft
         2. 0.15" – 0.18" down from top edge
      ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
      iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
      iv. Remove hinge and de-burr holes in hinge and lid rim.
      v. Cleco lid to hinge with 5/32 clecos.
      vi. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle AD-07
   a. Install handle brackets.
      i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
      ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
      iii. Torque AN3 bolts to ??.

   b. Install handle
      i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
      ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
      iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
      iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
      v. At first end, remove bolt and repeat step iv.
      vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
      vii. Torque AN3 bolts to ??.

   c. Check handle
      i. Operate handle to ensure handle does not bind and springs hold handle in.
      ii. Snap handle into brackets to ensure handle locks.

   d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace AD-07
   a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
   b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
   c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
   d. Ensure brace is seated on lip of bushings before tightening nuts.
   e. Torque AN3 bolts to ??
   f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. Final Inspection — AD02

   Dual inspection by a different person than assembled the basket.

   a. Check for general condition and correct assembly:
      i. Bolts are tight
      ii. Rivets are installed correctly
      iii. Handle operates correctly
      iv. Lid brace operates correctly
   b. Check that PO/WO numbers have been recorded.

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-11

Date Open: 13 Jan 16

Complete (initial or SCA #)

1. Weld Lever Assembly – handle lever jig required — AD-07
   a. Set MS20615-4M3 monel rivet into socket in jig
   b. Set 36274-01 bushing into socket in jig
   c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
   d. TIG weld around bushing using ER308L rod.
   e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
   f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
   g. Record material POs on attached material list.

2. Clean up
   a. Clean lever assembly by media blasting with glass bead.
   b. Drill out lever bushing to O (0.316) on lathe:
      i. Grasp bushing in chuck, ensure rivet clears between the jaws.
      ii. Run at 300 RPM.
      iii. Apply a drop of Rapid-Tap to drill.
   c. De-burr.

3. Fabricate Handle Assembly — AD-07
   a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
   b. Measure across TOP side of levers.
   c. Cut handle tubing to length measured.
      i. Handles under 40" long: 1.0" x 0.035 round tube
      ii. Handles over 40" long: 1.0" x 0.065 round tube
   d. De-burr tube.
   e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
   f. Record material PO on attached material list.

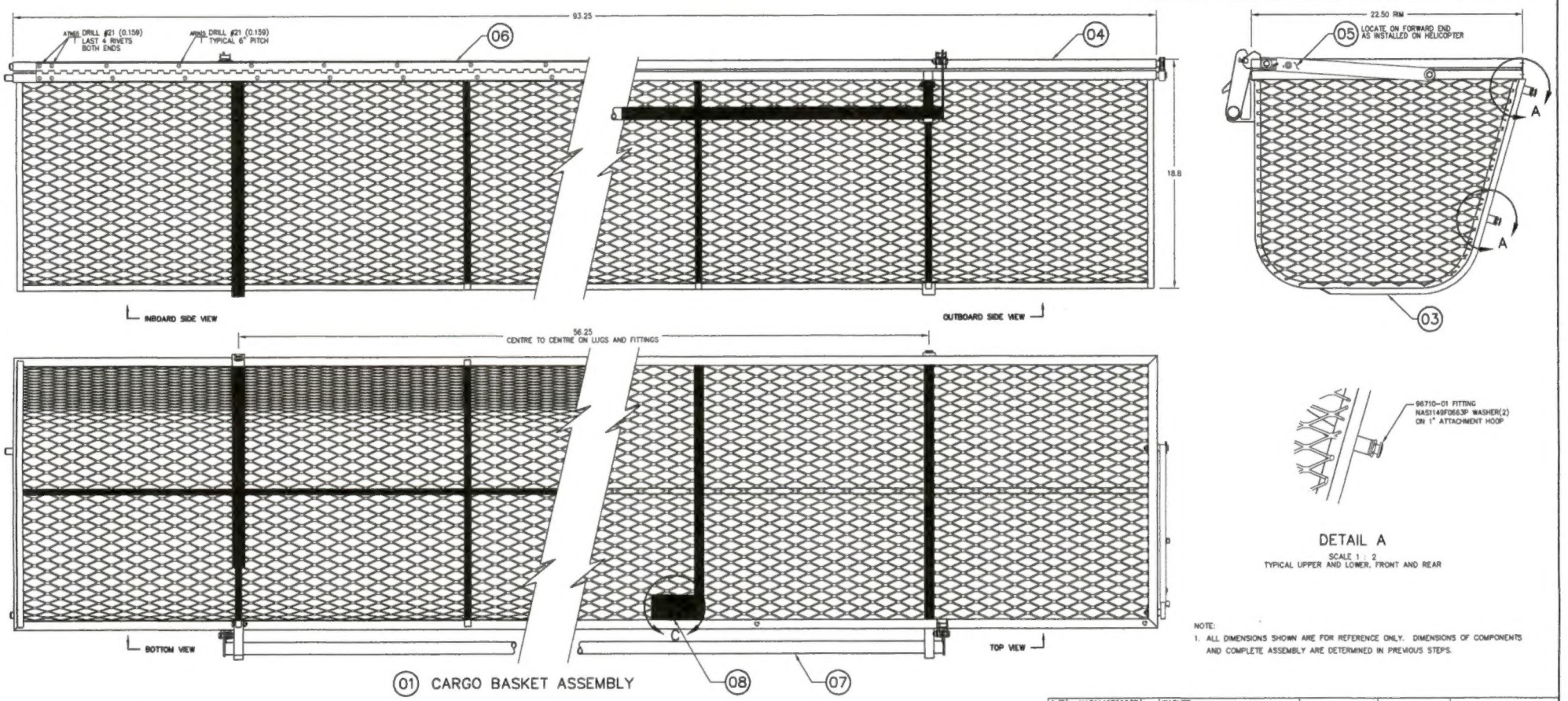
4. Weld Handle Assembly — AD-05
   a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up — AD-07
   a. Clean welded area with scotch-brite.

6. Final Inspection – AD02
   To be completed by a different person than the previous steps.
   a. Welds for complete and handle for fit.
   b. Tag complete and inspected parts in preparation for installation.

2016-11

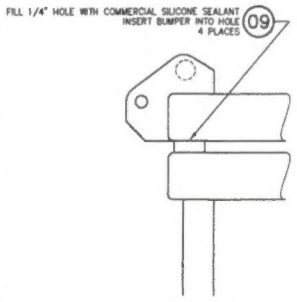
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BJC	27/01/2010
2	UPDATE TITLE BLOCK; ADD ALTERNATE RIVETS; HARDWARE P/NS UPDATED; HINGE LENGTH; CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	16/07/2014



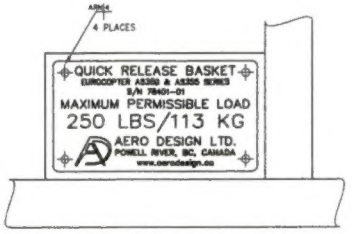
(01) CARGO BASKET ASSEMBLY

DETAIL A
SCALE 1 : 2
TYPICAL UPPER AND LOWER, FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

A/R	NAS1149F0663P		WASHER			
4	96710-01		FITTING	ALTERNATE: ANCRA 40088-14		
8	CR3523-5-02		CHERRY RIVET	ALTERNATE: HUCKMAX HR3523-5-02		
A/R	CR3213-5-02		CHERRY RIVET	ALTERNATE: HUCKMAX HR3213-5-02		
4	CR3213-4-02		CHERRY RIVET	ALTERNATE: HUCKMAX HR3213-4-02		
4	49205-14	09	BUMPER	ARGUS INDUSTRIES		
1	78427-01	08	PLACARD			
1	84255-01	07	HANDLE BAR INSTALLATION			
A/R	MS20001P4	06	PIANO HINGE			90.0 LONG
1	84240-01	05	LID BRACE INSTALLATION			
1	78412-01	04	LID ASSEMBLY			
1	78411-01	03	BASKET BODY ASSEMBLY			
		02				
	78410-01	01	CARGO BASKET ASSEMBLY			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. NAS 523
DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE
C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED
DASH NO. FOR LENGTH
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ATM=CR3523
INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS	DATE
DRAWN: R. RATHWELL	19 FEB 08
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES ±1/2°

AERO DESIGN LTD.
6868A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.3376
www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE SKI BASKET
BASKET ASSEMBLY (LONG)

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78410	2

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	27/01/2010
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:
   "QUICK RELEASE BASKET" – 0.125 HIGH
   "EUROCOPTER AS350 & AS355 SERIES" – 0.080 HIGH
   "S/N 78401-XX" – 0.080 HIGH
   "MAXIMUM PERMISSIBLE LOAD" – 0.125 HIGH
   "250 LBS/113 KG" – 0.200 HIGH
   "AERO DESIGN LTD." – 0.125 HIGH
   "POWELL RIVER, BC, CANADA" – 0.080 HIGH
   "www.aerodesign.ca" – 0.080 HIGH

01 PLACARD

PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: R. RATHWELL	18 FEB 08
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

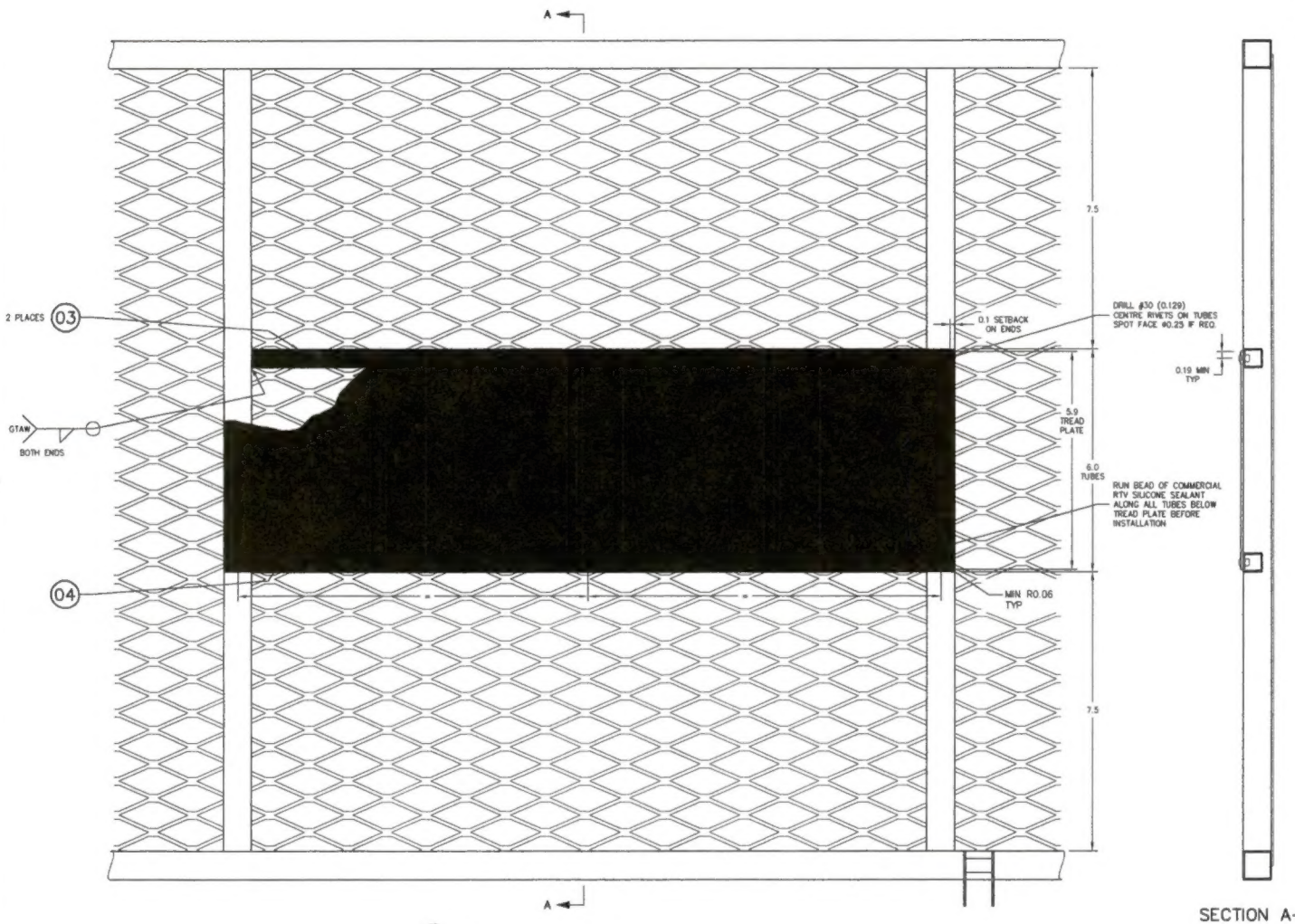
DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2376 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	78427	2

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	SJC	29/05/2014



(01) BASKET LID ASSEMBLY

SECTION A–A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER705-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02		BLIND RIVET	ALTERNATE: HR3213-4-02		
1	70405-04	04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03	TUBE	4130 STEEL COND. N	MIL-T-6738	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02	BASKET LID ASSEMBLY			
	70405-01	01	BASKET LID ASSEMBLY – MODIFIED WITH STEP			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. NAS 523

DASH NO. FOR DIAMETER
N=MFD. HEAD NEAR SIDE
F=MFD. HEAD FAR SIDE

C=COUNTERSUNK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED

DASH NO. FOR LENGTH

BASIC CODES:
BJ = MS20470AD
BB = MS20426AD
ARN = CR3213
ARM = CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS		DATE
DRAWN:	JEFF CLARKE	21 SEPT 2008
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

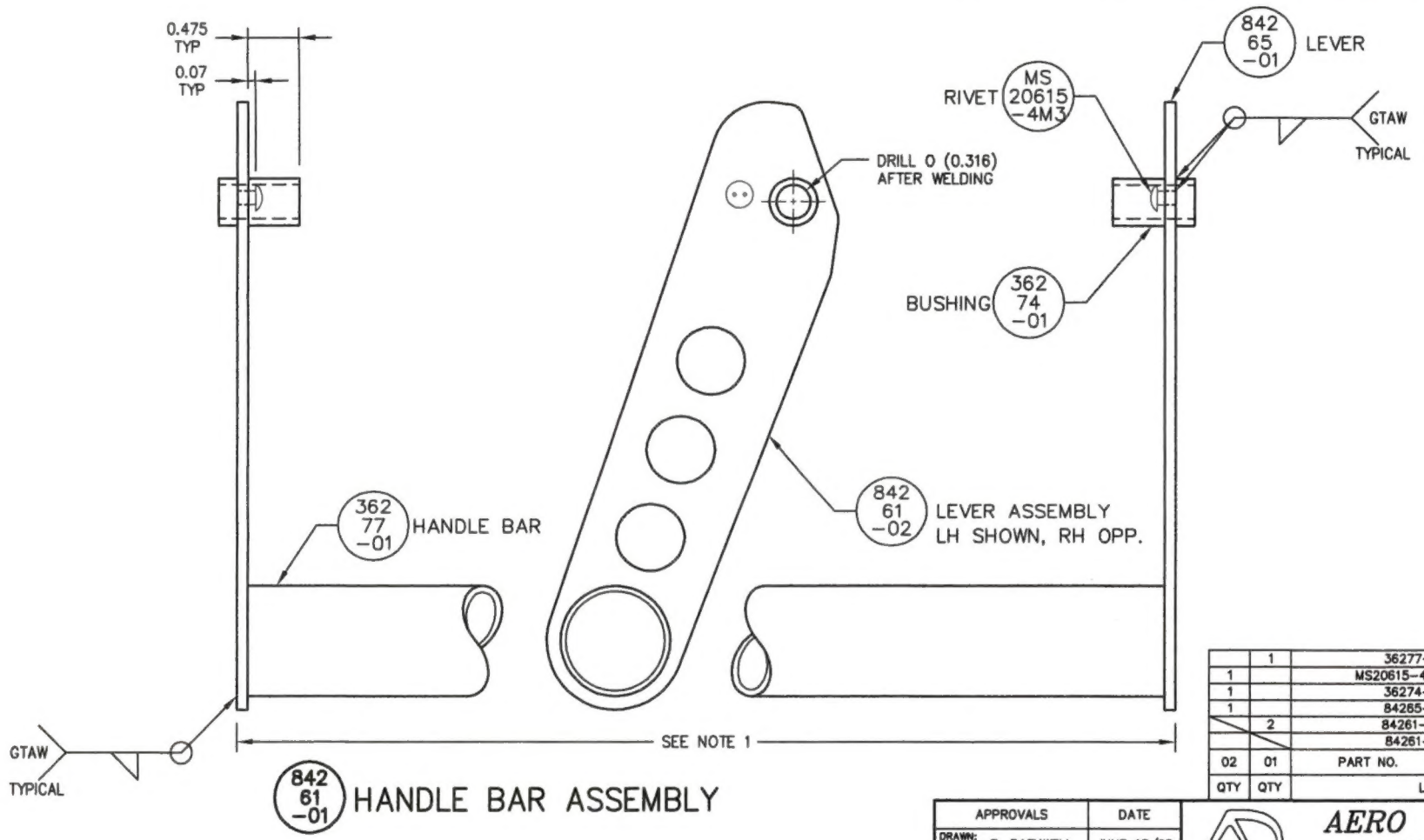
DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.8976 www.aerodesign.co

CARGO BASKET
LID STEP MODIFICATION

SCALE 1 : 1.5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	70405	4

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



842 61 -01 HANDLE BAR ASSEMBLY

NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

02 QTY	01 QTY	PART NO.	DESCRIPTION
	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
	2	84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2